



Dart Aerospace Ltd.
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D2620
Job Sheet 208533



Part No: D2620

Job Qty: 8 pcs

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/23/20

Job Tracking No:

Due Date: 4/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	8 pcs	4/20/20	4/20/20	0.00	2.11	Skidtubes - Bend		03
110	QC 5	8 pcs	4/20/20	4/20/20	0.00	0.00	QC 5 - 10		9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	8 pcs	4/20/20	4/20/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



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Container No: S274216



Part: D2620

Job No: 208533

Serial No/Batch: S274216

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/28/20

				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				Packaging 3 - 37 - B4B					
				130 QC 21 - SA	8 pcs	4/20/20	0.00 0.00	QC 21 - SA - 21	APR 29 2020 DAS 70
								QC 21 - SA - 70	
								QC 21 - SA - 53	9-89
				Part Op 100 - Skid tubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Descriptions: Cut Fwd end of tube as per Dwg D2620 110 - QC5- Inspect part completeness to step on W/O) 120 - Identify as per dwg & Stock Location: _____ LOCATION : LG002 130 - QC21- Final Inspection - Work Order Release					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				D2600-1-160	Extrusion Round 3" 206	8 pcs (1 ea)	100-Skid tubes - Bend - 1	5236156	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
				100-Skid tubes - Bend - 1	D2600-1-160	8	116	0	
				Part Specifications					
Specifications could not be found.									

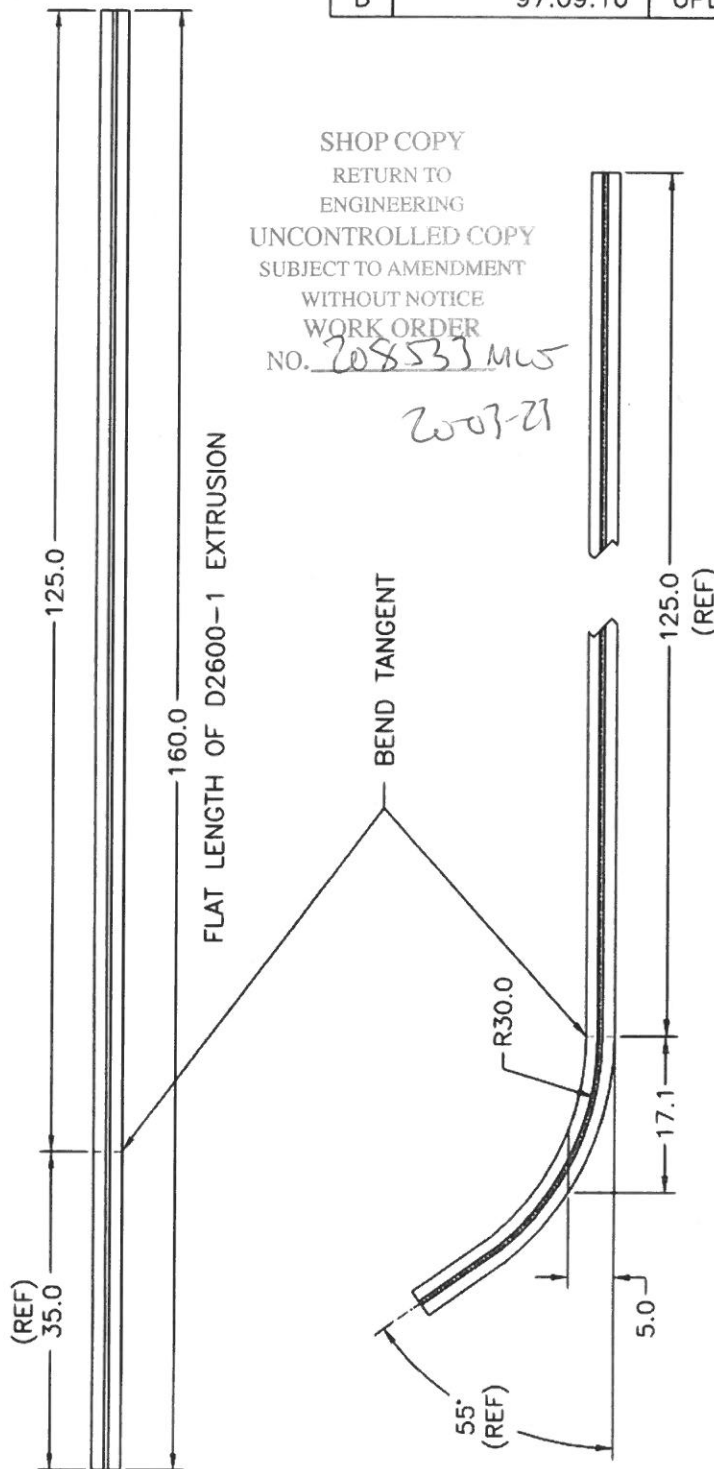
Plex 3/23/20 8:22 AM Dart.lajeunesse.marie

DART

DESIGN #	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED #	APPROVED KE	DRAWING NO. D2620	REV. B SHEET 1 OF 1
DATE 99.09.10		TITLE 206 SKIDTUBE BENDING CONTROL	SCALE 1:20
A	97.11.07	NEW ISSUE	
B	97.09.10	UPDATE FOR IN-HOUSE BENDING	

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

**RELEASED**
49.09.15 DS

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
4. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
5. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
6. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)					
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor					
				QC / QA Coordinator					

Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
		Other/Details:									